

CLAIMS

1. A seat ring with insert for a butterfly valve comprising an annular insert fitted in a seat part fitted on the valve body inner peripheral surface and comprising a valve body fitting annular groove having side wall parts on both
5 the upstream side and downstream side, wherein there are provided on the outer peripheral surface of the insert a step so that the outer diameter on the downstream side is smaller than the outer diameter on the upstream side, and a locking projection on the inner peripheral surface, and the insert is fitted in an annular groove provided in the valve body fitting annular groove of the seat
10 part.

2. A seat ring with insert for a butterfly valve according to claim 1, wherein the valve body fitting annular groove has a side wall part on the downstream side with a thickness of 2-5 mm.

3. A seat ring with insert for a butterfly valve according to either one of
15 claim 1 or claim 2, wherein there is provided a fitting groove or fitting protrusion on the outer peripheral surface of the insert in the tube stem direction.

4. A manufacturing method for a seat ring with insert for a butterfly valve wherein a die formed of an outer die, upper die and lower die is employed, and the insert having a fitting groove or fitting protrusion on the outer peripheral surface thereof engages with a fitting protrusion or fitting groove formed on the
- 5 inner peripheral surface of the outer die, the outer die, being in a state where the insert is engaged with the inner surface thereof, is sandwiched between the upper die and lower die, and rubber is injected in the die in a state where stem cores are fitted in stem core through holes provided on the outer die and a seat part is thus molded.